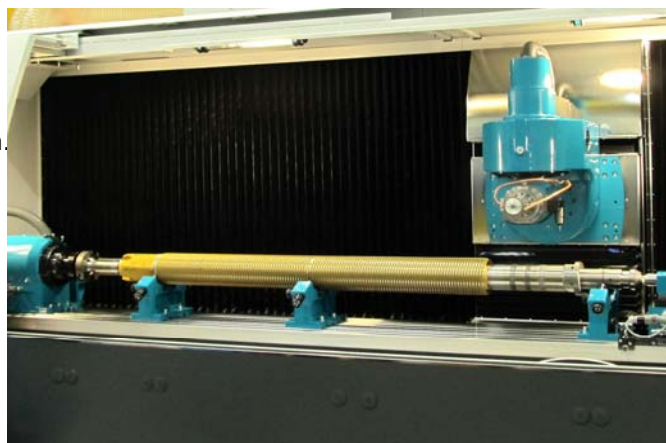





Cylindrical broach Ø170 z154

A14-020

The resharpener process of this example tool contains regrinding of the groove with total removal amount of 0.1mm. The division can be reproduced either according a fixed definition in Quinto or based on the probed data.



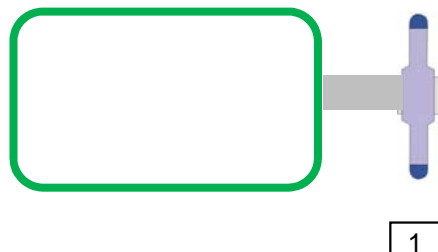
1. Cycletime for Resharpener

Workpiece: Diameter 170mm; Nr. of teeth 154 Material HSS			
Operations			
	Probe	Flute 1	
Feed [mm/Min]	3000	1	
Power [kW]		3	
Cutting feed [m/s]		30	
Used wheels			
		1	
Grinding time [min]	3	150	
Total cycle time	153 min		

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	14F1 Ø80 B91
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3. Machine and Software Requirements

Machines:	6 axes CNC grinders : Corvus BBA	Coolant:	Synthetic Oil, pressure 6 bar
Control:	Fanuc 31i	Software:	Quinto 5
Accessories:	Dog and driver, Hydraulic tailstock, Support		
Responsible engineer:	SIW, 12.12.2013		

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